

Date: Wednesday, 27/08/2008 11:34:39 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 41633					
Estimate Number	: 12734					
P.O. Number	:			Part Number	: D353525	
This Issue	: 27/08/2008		S.O. No. :	Drawing Number	: D3535 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 39716			Material	:	
Written By	:			Due Date	: 05/09/2008	
Checked & Approved By	<u>Julie Lecocq</u>			Qty:	20	Um: Each
Comment	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s) 304/316 .040 Sheet (M304S20GA)	
		Batch: <u>109088</u> <u>LB 8-9-2</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>B</u> <u>LB 8-9-2</u> Prog Rev: <u>B</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 11:34:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 41633

Part Number: D353525

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



QC 08/09/08 (X/16)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m106442

(26)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:25

OVEN TEMPERATURE: 320°

FINISH TIME: 10:55

F 08/09/08

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-1 08/09/08

(26x)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



26

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P 18

m-1 08/09/08

08/09/08

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mF 08-09-09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

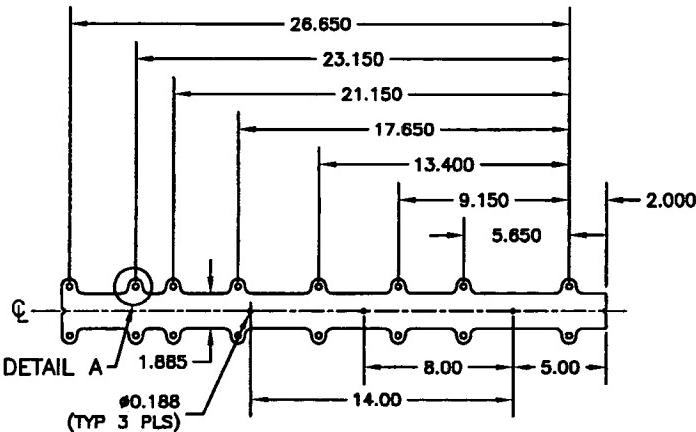
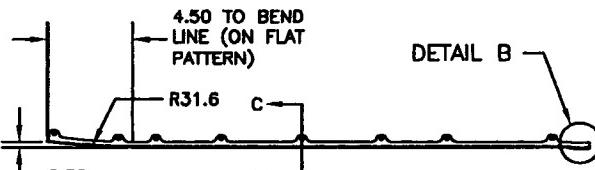
DART AEROSPACE LTD	Work Order:	41633
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS	Audited by:	✓	Prototype Approval:	N/A
Date:	8-9-2	Date:	08/09/02	Date:	N/A

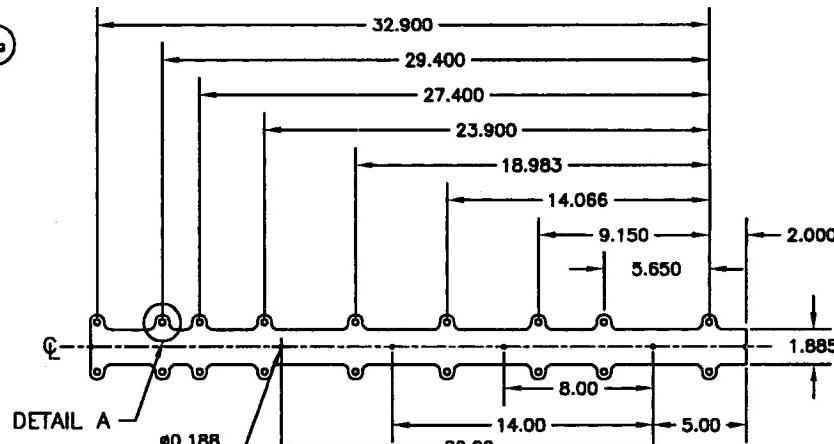
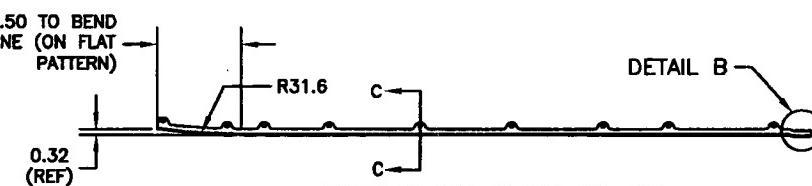
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WORK ORDER
NO. 41633

NOTES

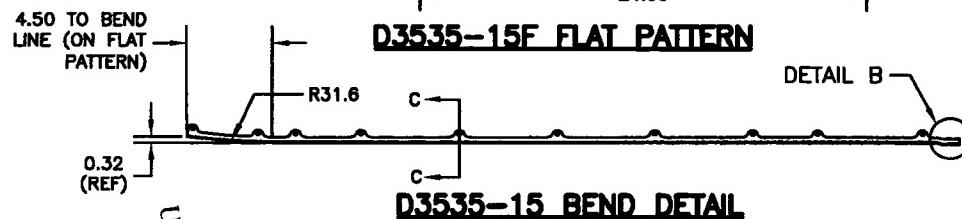
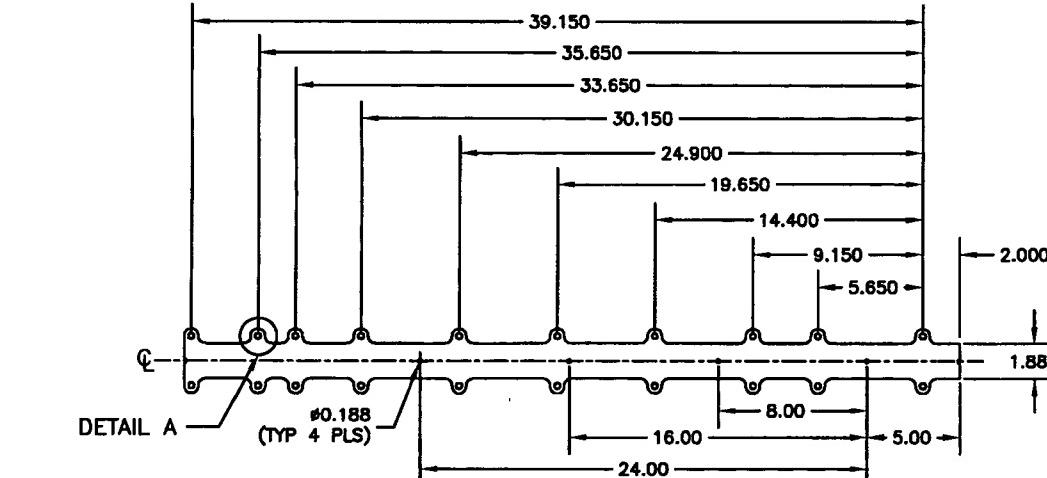
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	M	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[initials]</i>	<i>[initials]</i>	D3535
DATE	TITLE	SCALE
A 07.04.17	06.10.25 NEW ISSUE	1:10
B 07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

DART

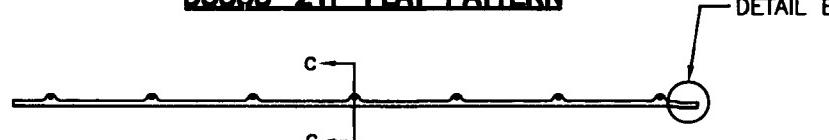
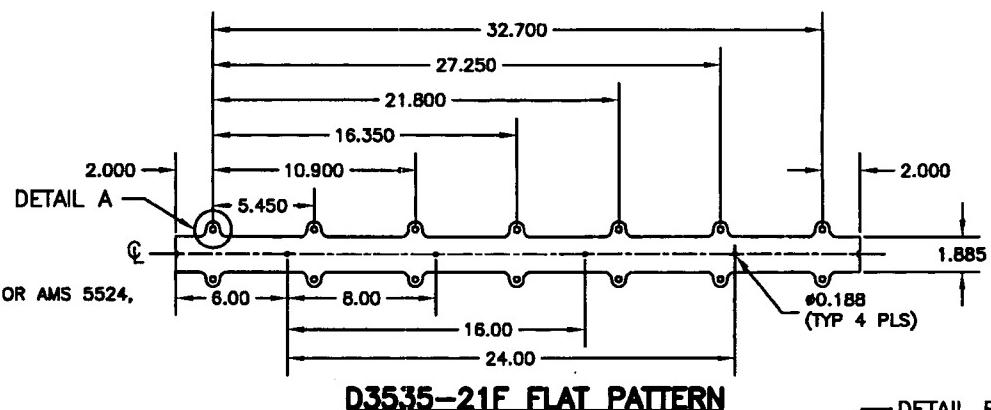
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CHECKED M	APPROVED M	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7 SCALE 1:10

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07.04.24 -M-

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NOTES

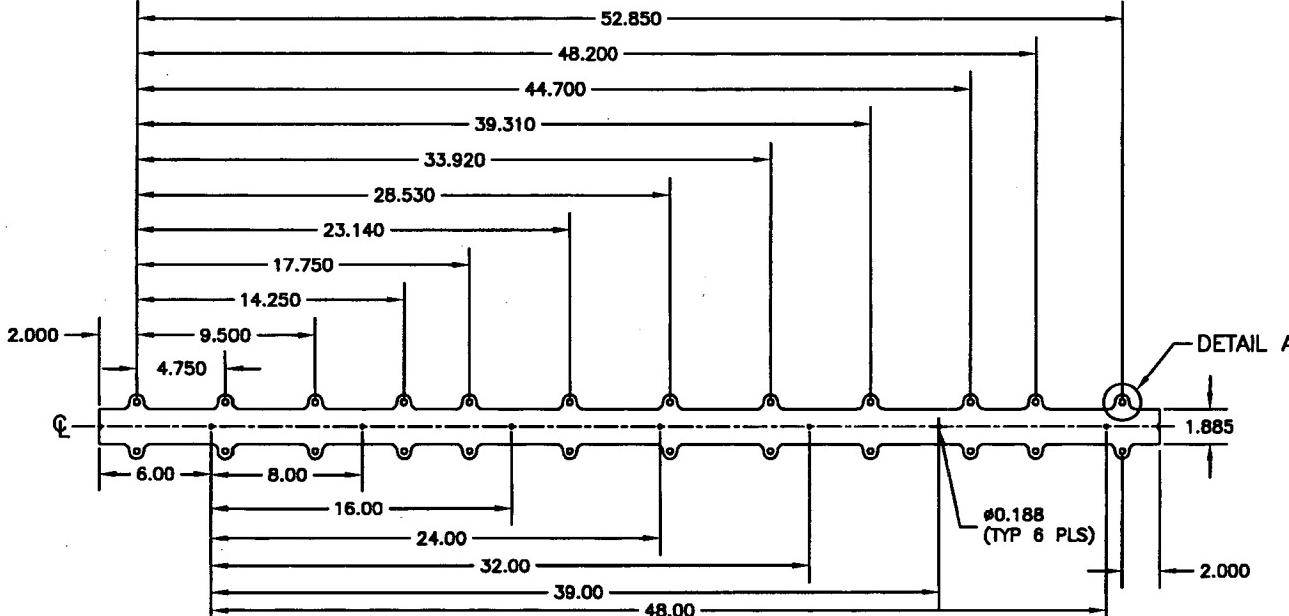
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

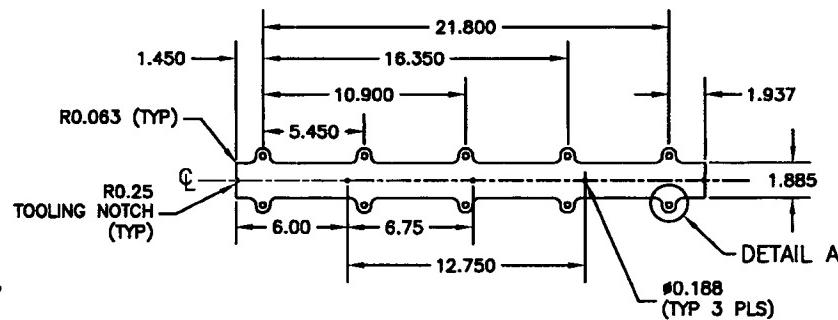
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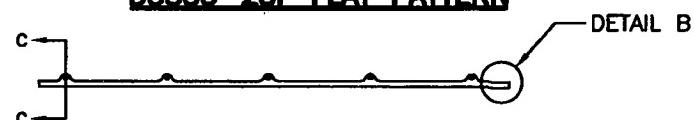
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D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION



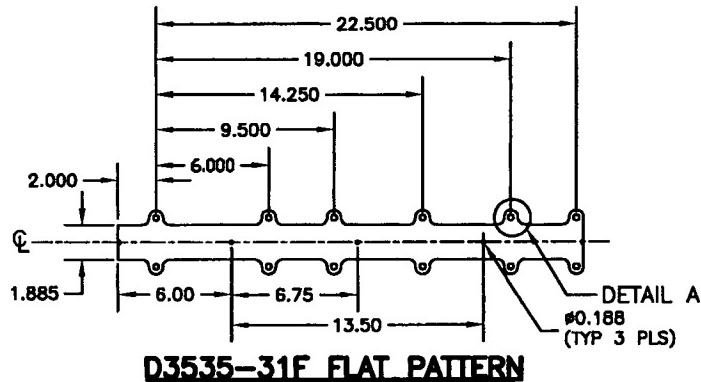
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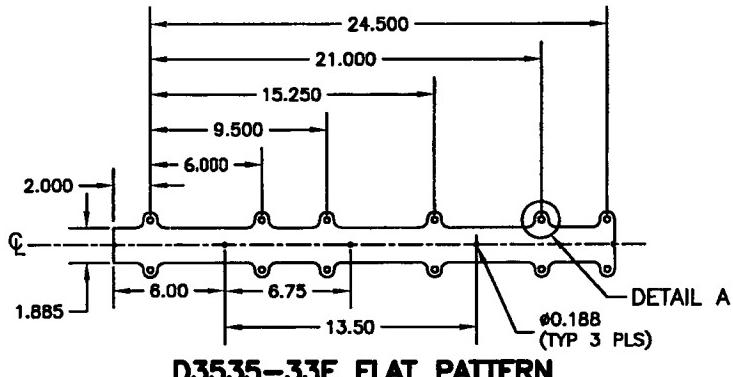
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D3535-31_BEND_DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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MÖJER

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
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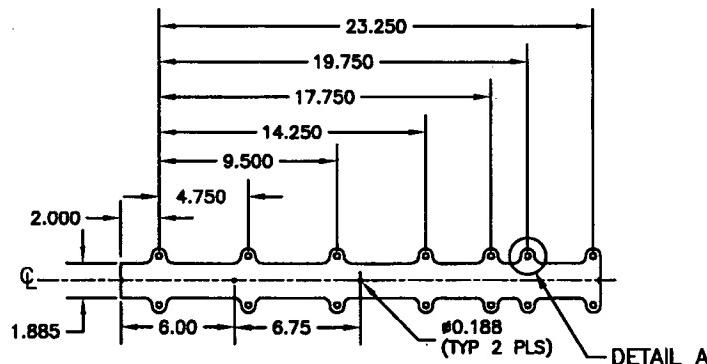
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			PORT HADLOCK, WA	
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DATE	07.04.17	TITLE	WEARSHOE	SCALE 1:10

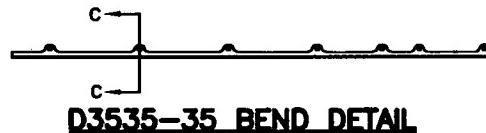
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D3535-35F FLAT PATTERN

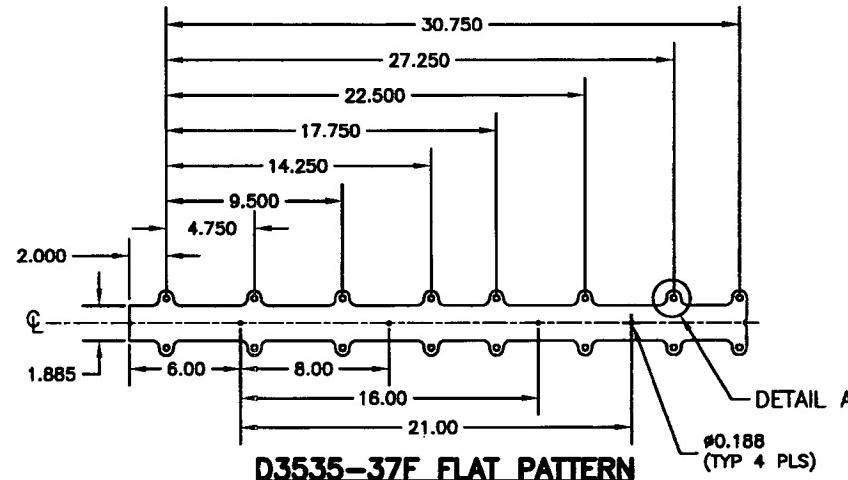


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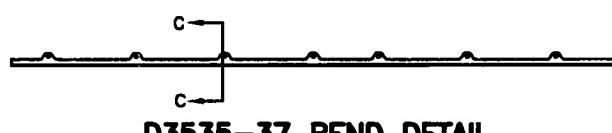
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07.04.17	<u>JH</u>	SHEET 5 OF 7 SCALE 1:10



D3535-37F FLAT PATTERN

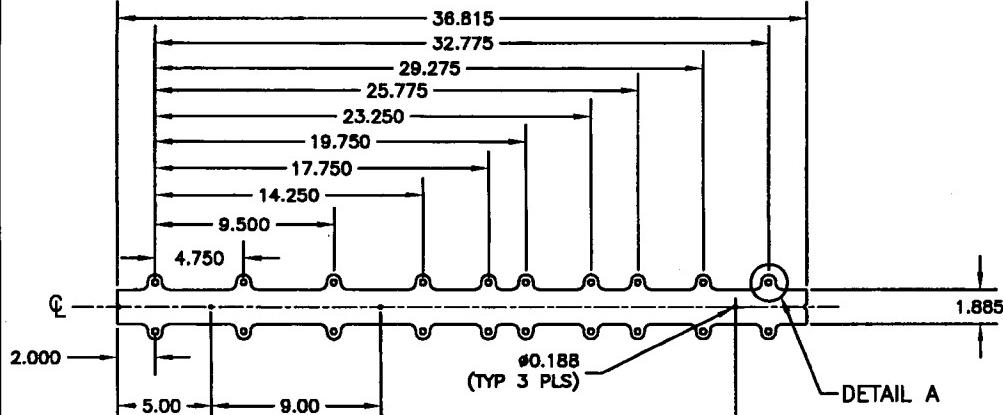
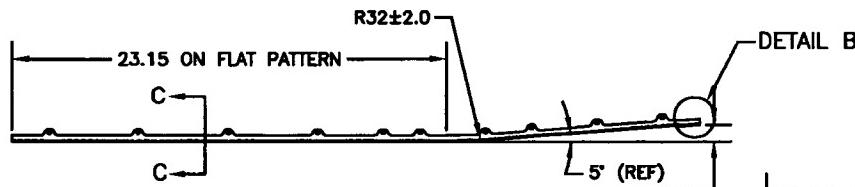
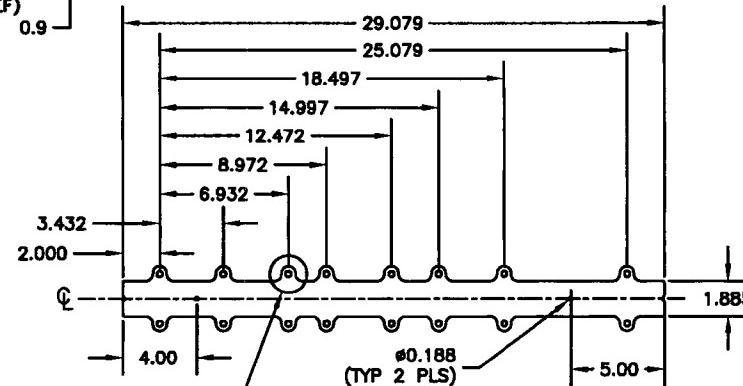
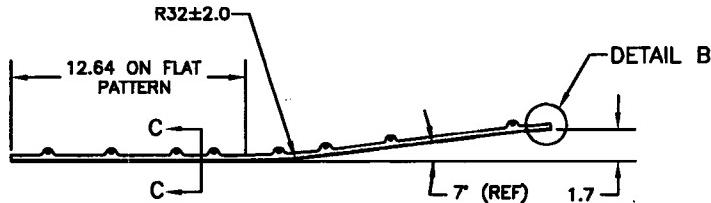


D3535-37 BEND DETAIL

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		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	

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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

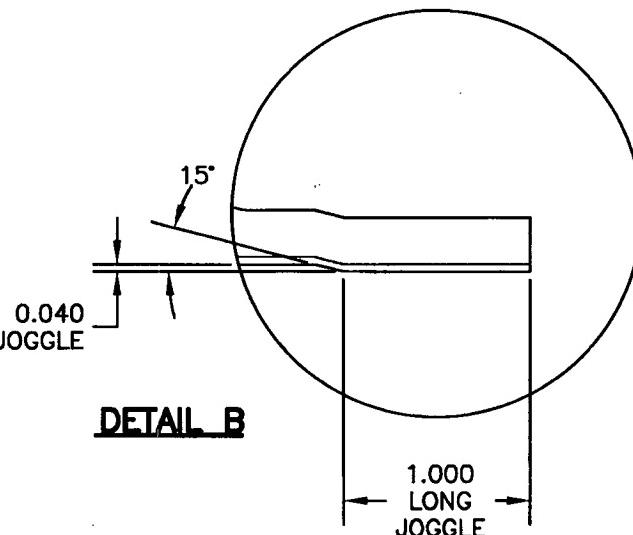
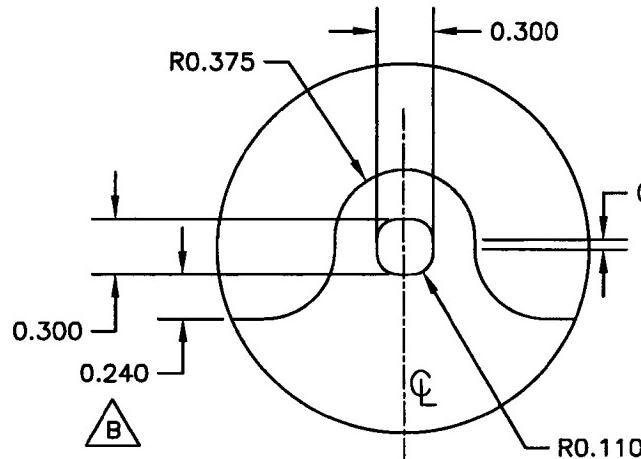
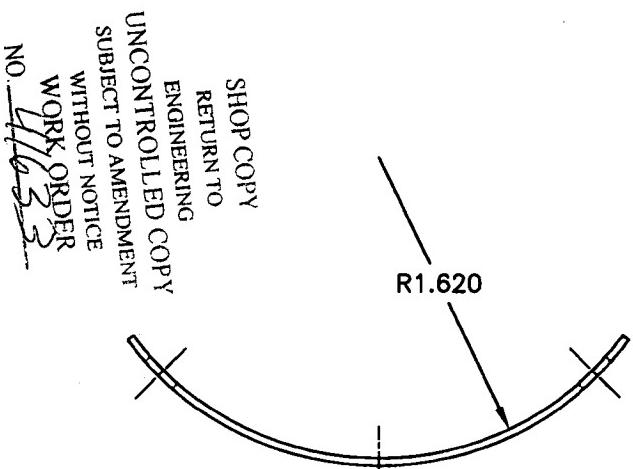
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		SHEET 7 OF 7 TITLE WEARSHOE SCALE 1:1

RELEASED
07.04.24**DETAIL B****DETAIL A****SECTION C-C**

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